

Work Order ID 71987

Friday, July 15, 2011 8:34:10 AM



Page 1

Item ID:	D412-630-032	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Pilot/Co-Pilot Step, RH (Folding)					
Start Date:	7/15/2011	Start Qty:	2.00	Cust Item ID:		
Required Date:	7/29/2011	Req'd Qty:	2.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	1-10-15	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-630	Rev M								

100
 DOCUMENT CONTROL *X* 0.00
 DC Memo 0.00
 Document Control Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG003 *Subs/16* *CL 11-8-23*

110
 Small Fab 0.00
 Small Fab Memo 0.00
 Small Fab Assemble as per dwg D412-630 p.17
 ****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****
 A/R MS20995C41 batch: *M114830* *EF 11/08/22 (2)*

120
 QC5- Inspect part completeness to step on W/O 0.00
 QC Memo 0.00 *Subs/22* *x2 RH*
 Quality Control ****ensure tension to retract step is 11 to 18 lbs ****
 Test fit on aircraft in Eng. lab.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71987

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Item ID: D412-630-032

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging Packaging	Pick Kit Memo	0.00 0.00							
140 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							
150 Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D412-630-032 Location: _____ PPP Rev: <u>D</u>	0.00 0.00							

SP 11 - 08-24.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: * D412-630-032

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/11

ME
11-09-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Page 1

**Start Date:** 7/15/2011**Required Date:** 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

Comments:	IPP REV. A	05.11.21	NEW ISSUE	EC	
	IPP REV. B	05.12.19	updated pick list	EC	
	IPP REV.C	07.11.12	ecn 1019, nochg	EC	verifiedby:DD IPP Rev:D
	10.05.28	added route seq	DD	verf:EC	IPP Rev: E 11.06.01
	removed qty1	an310-4	EC	verified by: DD	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4  NUT		Purchased	No			110	Each	76.0000	1	2		EP 08/22	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST324				76				2	
				118078				26					
				118112				50					
MS24665-302  Cotter Pin		Purchased	No			110	Each	180.0000	1	2		EP 08/22	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST357				180				2	
				117460				180					
AN310-5  NUT		Purchased	No			130	Each	42.0000	1 2	4		SP 11-08-24	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST324				42				4	
				114830				12					
				118112				30					

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 2

Work Order ID: 71987

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

AN3C5A



Bolt

Purchased

No

130

Each

1,183.000



6

sp 11-08-24

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1176

116419

28

116549

42

117343

500

117764

300

117872

306

6

AN44-C12



eyebolt

Purchased

No

130

Each

19.0000



2

sp 11-08-24

Location

Loc Qty

Loc Code

ST362

19

117616

19

2

AN4C15



BOLT

Purchased

No

130

Each

17.0000



2

sp 11-08-24

Location

Loc Qty

Loc Code

ST358

17

117764

7

118091

10

2

AN5C11



BOLT

Purchased

No

130

Each

29.0000



2

sp 11-08-24

Location

Loc Qty

Loc Code

ST337

29

114801

29

2

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 71987

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

8
2
 AN5C15

 BOLT

Purchased No 130 Each 23.0000

1
2


 SP 11-08-24 S

Location Loc Qty Loc Code


ST338 23

114669 3

117616 20

8
2
 AN960C10

 WASHER

Purchased No 130 Each 0.0000

7
14

 SP 11-08-24 S

m 114742 14 x

Location Loc Qty Loc Code

ST347 27

102842 27

8
2
 D3454-1

 Bushing

Manufactured No 130 Each 16.0000

1
2

 SP 11-08-24 S

Location Loc Qty Loc Code

ST054 16

58555 16

8
2
 D3454-3

 Bushing

Manufactured No 130 Each 22.0000

2
4

 SP 11-08-24 S

Location Loc Qty Loc Code

ST058 22

56420 2

68467 20

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 4

Work Order ID: 71987

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

D3454-5

Manufactured No

130 Each

24.0000

2 4



Bushing

Location

Loc Qty

Loc Code

ST054

24

68468

4

70527

20

Manufactured No

130 Each

15.0000

4 8



Spacer

Location

Loc Qty

Loc Code

ST054

15

68469

1

70529

14

Manufactured No

130 Each

13.0000

2 4



Spacer

Location

Loc Qty

Loc Code

ST054

13

68470

13

Manufactured No

130 Each

1.0000

1 2



Bracket Assembly

Location

Loc Qty

Loc Code

ST198A

1

70530

1

SP11-08-24

SP 11-08-24

B72133 8x

SP 11-08-24

4

SP11-08-24

B71704 11/16

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 5

Work Order ID: 71987

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

MS21043-3

Purchased

No

130

Each

872.0000

3

6



Nut



SP 11-08-24 SP

Location

Loc Qty

Loc Code

FG	72	
103691	72	
ST301	800	
112314	65	
118077	735	

MS24665-227

Purchased

No

130

Each

115.0000

2

4



COTTER PIN



SP 11-08-24 SP

Location

Loc Qty

Loc Code

GA	97	
111041	97	
ST309	18	
113845	18	

NAS1515H5

Purchased

No

130

Each

163.0000

1

2



Washer



SP 11-08-24 SP

Location

Loc Qty

Loc Code

FG	40	
103286	20	
103691	20	
ST277	123	
103286	100	
109430	23	

m 118384 2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 71987

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

D3455-1 ?

Manufactured No

110 Each

15.0000

2

4



Spacer

Location

Loc Qty

Loc Code

ST054

15

68469

1

70529

14

D3443-041 ?

Manufactured No

110 Each

0.0000

1

2



Strut Weldment Assembly

D3463-042 ?

Manufactured No

110 Each

1.0000

1

2



Step Weldment Assembly

Location

Loc Qty

Loc Code

ST494

1

68473

1

D3443-9 ?

Manufactured No

110 Each

2.0000

2

4



Pin

Location

Loc Qty

Loc Code

ST053

2

70526

2

AN4C14 ?

Purchased No

110 Each

35.0000

1

2



BOLT

Location

Loc Qty

Loc Code

ST357

25

117688

25

ST358

10

114669

10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 71987

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

MS24665-229

Purchased

No

130

Each

315.0000

2

4



COTTER PIN



SP 11-08-24.8

Location

Loc Qty

Loc Code

GA

200

118234

200

ST309

115

111041

115

MS24665-227 7

Purchased

No

110

Each

115.0000

1

2



COTTER PIN



SP 11-08-22

Location

Loc Qty

Loc Code

GA

97

111041

97

ST309

18

113845

18

AN4CH3 7

Purchased

No

110

Each

24.0000

2

4



SS Bolt



SP 11-08-22

Location

Loc Qty

Loc Code

ST357

24

117616

14

118131

10

D3465-1 7

Manufactured

No

110

Each

14.0000

1

2



Washer



SP 11-08-22

Location

Loc Qty

Loc Code

ST054

14

46134

14

Friday, July 15, 2011 8:34:40 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 71987

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

AN310-4

Purchased No

130 Each

76.0000

1



NUT

Location

Loc Qty

Loc Code

ST324

76

118078

26

118112

50

D3443-043

Manufactured No

110 Each

0.0000

1



Strut Weldment Assembly

D3454-7

Manufactured No

110 Each

24.0000

2



Bushing

Location

Loc Qty

Loc Code

ST058

24

70528

24

AN310-7

Purchased No

110 Each

37.0000

1



NUT

Location

Loc Qty

Loc Code

ST324

37

114784

37

[Handwritten signature]
SP 11-08-24

B72031 (20)

[Handwritten signature] 5/11/08/22

[Handwritten signature] 5/11/08/22

[Handwritten signature] 5/11/08/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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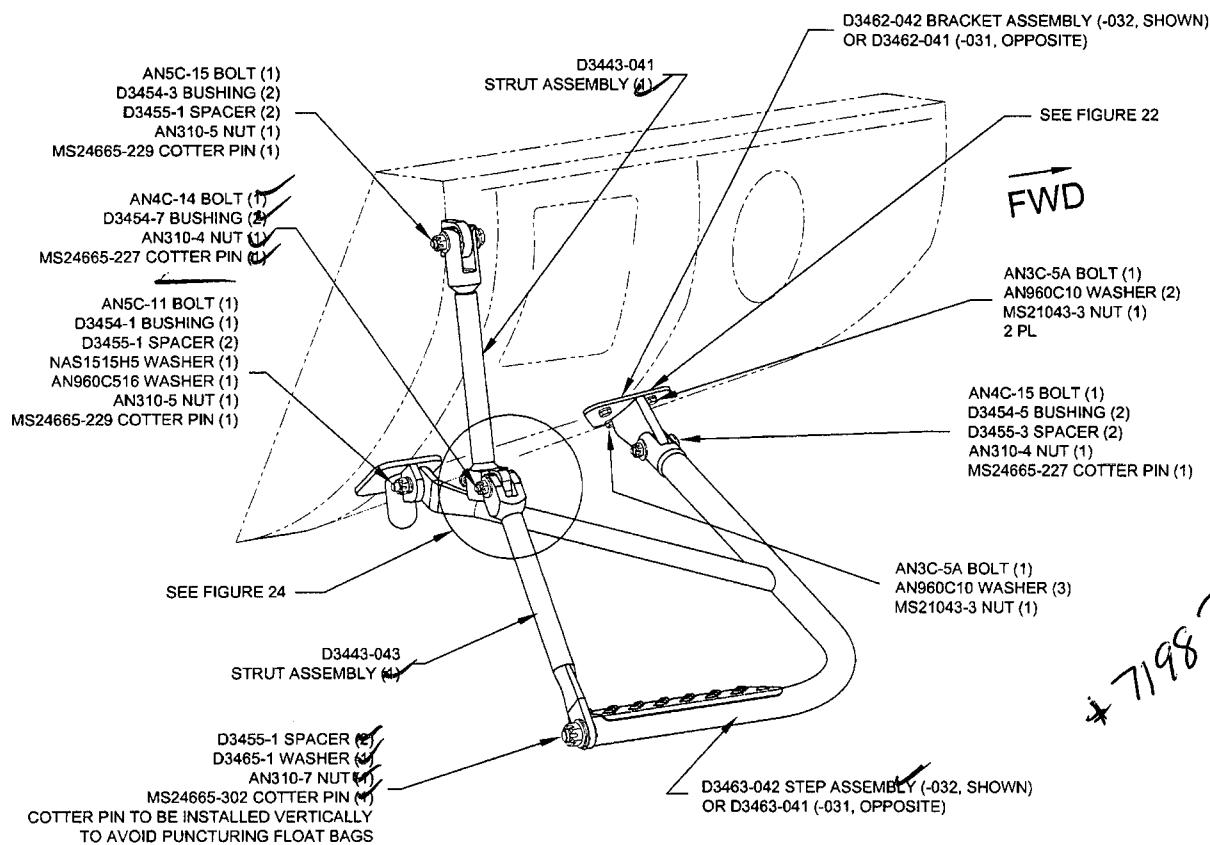


FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

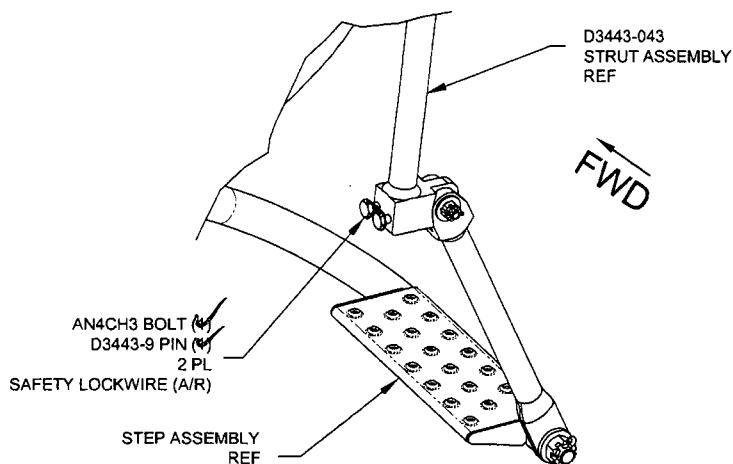


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

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Revision: M
Date: 08.12.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

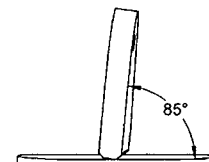
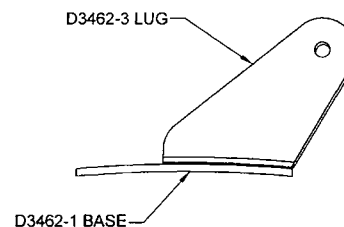
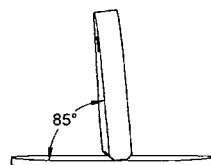
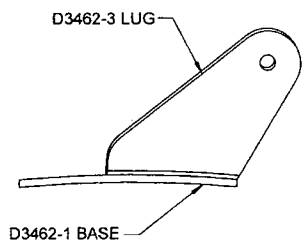
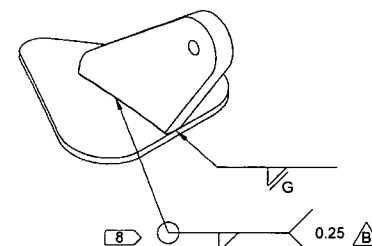
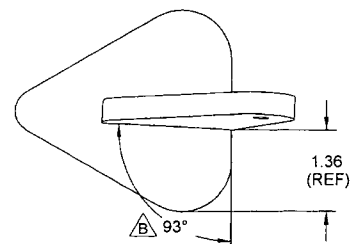
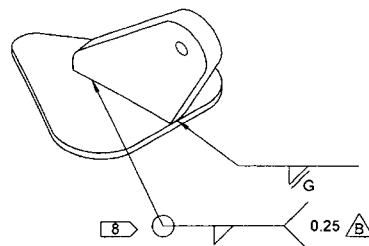
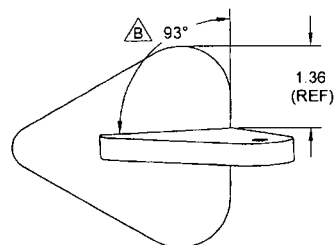
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER (2)
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
1	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT (1)
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN (1)
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP



D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.24		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3462	REV. C
TITLE BRACKET ASSEMBLY	SCALE 1:2
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REFERENCE ONLY